

Work Order ID 139557-2

Monday, November 30, 2015 11:07:52 AM

139557

Page 1

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Bracket

Start Date: 11/30/2015 Start Qty: 2.00

Required Date: 11/30/2015 Req'd Qty: 2.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: MLJ

Date: DEC 02 2015

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2341

Rev F

D2360

Rev D

100

100

Bandsaw

Jeaspa Bandsaw

BAND SAW

0.00

Memo

Cut blanks: 12.65" Long

0.00

10 0 16/01/28

110

110

HAAS 1

HAAS CNC vertical machine #1

HAAS CNC VERTICAL MACHINING #1

0.00

Memo

Machine as per Folio D2341 and Dwg D2341
2-Deburr

0.03

10 0 DAS 20 9-89 16-01-29

Work Order ID 139557

Monday, November 30, 2015 11:07:52 AM

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Page 2

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Bracket

Start Date: 11/30/2015 Start Qty: 2.00

Required Date: 11/30/2015 Req'd Qty: 2.00

Reference:

Accept

N9000040100

Setup Start ***NS1***

Stop ***NS2***

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start ***NR1***

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

120

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

10

~~10~~

DAS

20

9-89

16-01-29

130

130

QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

10

~~10~~

DAS

14

9-89

16/02/01

140

140

HandFinish

Hand Finishing

Chemical Conversion Coat per QSI005 4.1

0.00

Memo

0.00

10

16-2-2 JK

Work Order ID 139557

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139557

Page 3

Item ID: D2360

Revision ID:

Item Name: Litter Tie Down Bracket

Start Date: 11/30/2015 Start Qty: 2.00

Required Date: 11/30/2015 Req'd Qty: 2.00

Reference:

Accept

N9000040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

150

Powdercoat
Powder Coating

M 130 709

Memo

0.00

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10 0 1602-3 338

160

QC3- Inspect Part Finish

0.00

160

QC

Quality Control

Memo

0.00

7X 16/02/07

DAS
36
9-89

170

170

Small Fab

Small Fab

Small Fab

Memo

Assemble as per dwg D2360

0.00

0.01

7X 16/02/07

DAS
36
9-89

☆
PTD

open holes #D 2x
ø .246

Work Order ID 139557

Monday, November 30, 2015 11:07:52 AM

139557

Page 4

Item ID: D2360

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Litter Tie Down Bracket

Start Date: 11/30/2015 Start Qty: 2.00

2

Cust Item ID:

Required Date: 11/30/2015 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

7

DAS
38
9-89

FEB 09 2016

190

Identify as per dwg & Stock Location: Stamps

0.00

190

Packaging

Memo

0.00

Packaging

7

DAS
6
9-89

FEB 09 2016

200

QC21- Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MCS

FEB 10 2016

MCS

FEB 11 2016

Picklist Print

Monday, November 30, 2015 11:07:51 AM

Page 1

Work Order ID: 139557

139557

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP rev H 07.06.12 ecn 825 EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

AN526C1032R18

Purchased

No

170

Each

178.0000

1

~~10~~ 10

AN526C1032R18

Screw

**

DAS

8

9-89

Location

Loc Qty

Loc Code

FP001

72

4523

72

ST327

106

108079

106

D2002-015

Manufactured

No

170

Each

2.0000

2

~~40~~ 20

D2002-015

Knob

**

DAS

30

9-89

Location

Loc Qty

Loc Code

GA

2

136185

2

D2345

Manufactured

No

170

Each

15.0000

1

~~40~~ 10

D2345

Lock Channel

**

DAS

30

9-89

Location

Loc Qty

Loc Code

GA

15

133107

2

135400

3

136913

10

D2366

Manufactured

No

170

Each

7.0000

2

~~40~~ 20

D2366

Lock Handle

**

DAS

8

9-89

Location

Loc Qty

Loc Code

ST006

7

136142

7

FEB 03 2016

DAS

8

9-89

DAS

8

9-89

DAS

8

9-89

Picklist Print

Monday, November 30, 2015 11:07:51 AM

Page 2

Work Order ID: 139557

139557

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 2.00

Required Qty: 2.00

D2367

Manufactured No

170 Each 10.0000 1 2 10

D2367

Handle Knob

**

Location

Loc Qty

Loc Code

ST006

10

133384

4

135368

6

Manufactured No

170 Each 34.0000 2 20

D2372

D2372

Quick Release

**

DAS
30
9-89

Location

Loc Qty

Loc Code

GA

34

137780

6

137985

6

138467

6

139358

16

Manufactured No

170 Each 8.0000 1 2 10

D2373

D2373

Spring

**

DAS
30
9-89

Location

Loc Qty

Loc Code

GA

8

133425

8

Manufactured No

170 Each 4.0000 1 2 10

D2444

D2444

Pip Pin Assembly

**

DAS
30
9-89

Location

Loc Qty

Loc Code

GA

4

136647

4

B139614

Monday, November 30, 2015 11:07:51 AM

Shop Packet Print

Page 2

Picklist Print

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Page 3

Work Order ID: 139557

Parent Item: D2360

Parent Item Name: Litter Tie Down Bracket

139557

D2360

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 2.00

Required Qty: 2.00

D6201

Manufactured No

100 f

21.1380

1.054

2.218947

D6201

"T" Extrusion

Location

Loc Qty

Loc Code

MAT028

21.1380001

124165

0.0000001

133208

0.068

133910

1.07

137533

20

170

Each

1,652.000

1

2 10

DAS

6

3.89

MS20470AD3-4

Purchased

No

MS20470AD3-4

Rivet, Universal Head

Location

Loc Qty

Loc Code

GA

556

111477

556

ST310

1096

111477

1096

170

Each

362.0000

3

10

30

133790 HS

DAS

5

3.89

MS21042L3

Purchased

No

MS21042L3

Nut

Location

Loc Qty

Loc Code

FPO01

95

M130922

95

GA

84

M131317

84

ST304

183

M130922

183

FEB 03 2016

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Shop Packet Print

Page 3

Picklist Print

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Page 4

Work Order ID: 139557

139557

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 2.00

Required Qty: 2.00

MS27039-1-13

Purchased

No

170

Each

688.0000

1

2 10

MS27039-1-13

Screw

Location

Loc Qty

Loc Code

cck007a

295

124326

295

GA

90

124326

90

ST285

303

125654

303

MS27039-1-15

Purchased

No

170

Each

887.0000

2

4 20

MS27039-1-15

Screw

Location

Loc Qty

Loc Code

cck007a

800

m132640

600

m132701

200

GA

51

m127916

51

ST285

36

m127916

10

m130388

1

m132317

25

Monday, November 30, 2015 11:07:51 AM

Shop Packet Print

Page 4

Picklist Print

Monday, November 30, 2015 11:07:51 AM

Page 5

Work Order ID: 139557

Parent Item: D2360

Parent Item Name: Litter Tie Down Bracket

139557
D2360

NAS1149D0332J

Purchased

No

NAS1149D0332.J

Washer

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 2.00

Required Qty: 2.00

170 Each 2,007.000 8 16

**

DAS
36
9-89

16/02/07

Location

Loc Qty

Loc Code

CA

14

m129682

14

FP001

76

m129682

76

GA

357

m132677

357

ST264

1560

m133498

1560

56

NAS1149D0363J

Purchased

No

NAS1149D0363.J

Washer

170.0000 2 4

**

DAS
36
9-89

16/02/07

Location

Loc Qty

Loc Code

GA

141

m130799

141

ST269

29

m126319

7

m128429

2

m131618

1

m132317

10

m132677

9

14

Monday, November 30, 2015 11:07:51 AM

Shop Packet Print

Page 5

Picklist Print

Monday, November 30, 2015 11:07:51 AM

Page 6

Work Order ID: 139557

139557

Parent Item: D2360

D2360

Parent Item Name: Litter Tie Down Bracket

Start Date: 11/30/2015

Required Date: 11/30/2015

Start Qty: 2.00

Required Qty: 2.00

NAS679A3W

Purchased

No

170

Each

262.0000

1

2

NAS679A3W

Nut

DAS

30

8-89

FEB 04 2016

Location

Loc Qty

Loc Code

GA

140

1463

5

M2409

135

Mezz

122

2409

122

10

Monday, November 30, 2015 11:07:51 AM

Shop Packet Print

Page 6

DART AEROSPACE LTD		Work Order: 139557
Description: Litter Tie Down Bracket (Locking)		Part Number: D2341
Inspection Dwg: D2341	Rev: F	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

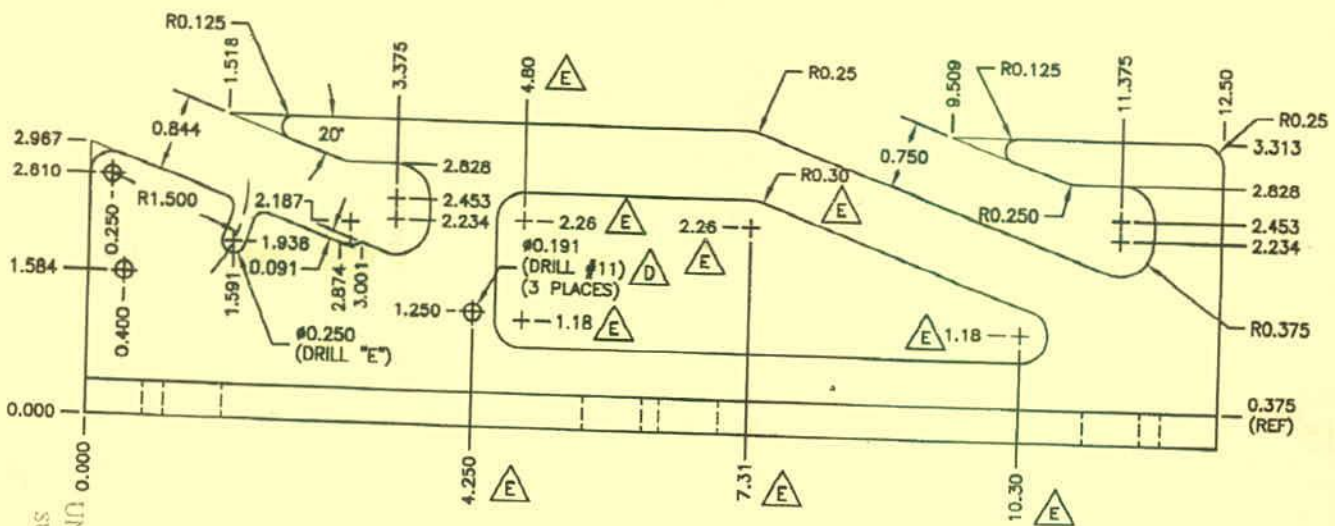
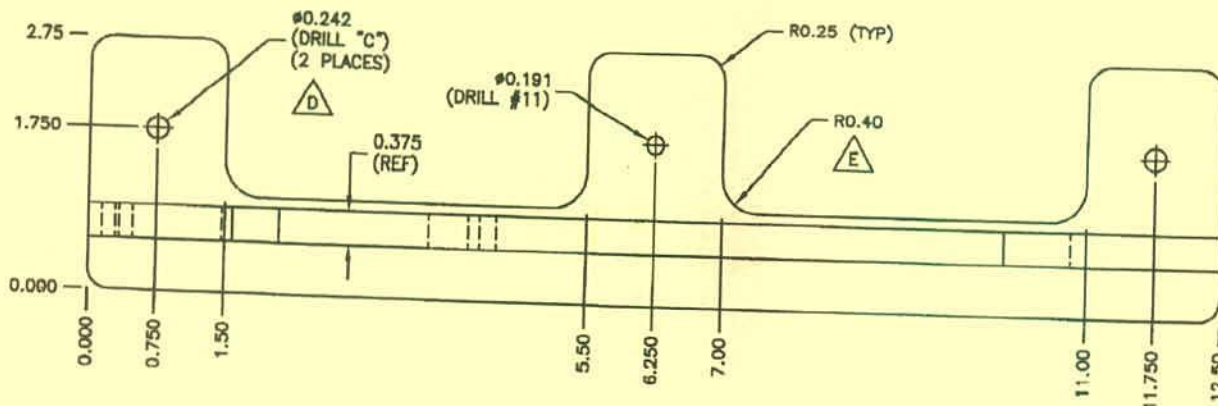
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.750	+/-0.010	1.753	✓		SLIO	Vern
2.75	+/-0.030	2.757	✓		"	
Ø0.242	+0.005/-0.001	0.242	✓		"	
Ø0.191	+0.005/-0.001	0.192	✓		"	
R0.25	+/-0.030	0.250	✓		Rad gauge	
R0.40	+/-0.030	0.400	✓		"	
12.50	+/-0.030	12.507	✓		Height gauge	
11.750	+/-0.010	11.755	✓			
11.00	+/-0.030	11.0025	✓			
7.00	+/-0.030	7.0075	✓			
6.250	+/-0.010	6.256	✓			
5.50	+/-0.030	5.504				
1.50	+/-0.030	1.510	✓			
0.750	+/-0.010	0.757	✓			
0.400	+/-0.010	0.399	✓		SLIO	Vern
1.584	+/-0.010	1.5815	✓			
2.610	+/-0.010	2.608	✓			
0.250	+/-0.010	0.248	✓			
0.844	+/-0.010	0.842	✓			
Ø0.250	+/-0.010	0.249	✓			
0.750	+/-0.010	0.752	✓			
3.313	+/-0.010	3.312	✓			
4.250	+/-0.010	4.248	✓			
1.250	+/-0.010	1.248	✓			

Measured by: DAS 20 9-89	Audited by: DAS 14 9-89	Prototype Approval:	N/A
Date: 16-01-29	Date: 16/02/01	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.05.24	New Issue P/O D2360	KJ/JLM	
B	07.07.17	Dwg Rev. updated	KJ/JLM	
C	10.02.02	Dimensions updated	KJ	

DART

DESIGN BW	DRAWN BY DL	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2341	REV. F SHEET 1 OF 1
DATE 07.06.07	TITLE LITTER TIE DOWN BRACKET (LOCKING)		
		SCALE 1:2	
A	95.01.13	NEW ISSUE	
B	95.02.14	MODIFIED LOCK	
D	95.02.20	CHANGES TO DIAMETERS	
E	97.10.01	CHANGES FOR MACHINING	
F	07.06.07	REVISED NOTES; FINISH WAS ANODIZE	

**D2341 LITTER TIE DOWN BRACKET (LOCKING)**

- 1) MATERIAL: MAKE FROM D6201-0125 EXTRUSION (6061-T6/T651 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3
- 3) BREAK ALL SHARP EDGES TO 0.005 TO 0.010
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFY WITH DART P/N "D2341" USING FINE POINT PERMANENT INK MARKER

F

RELEASED

07.06.22

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SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 139557

MS 15-12-00

DART**RELEASED**

97.06.07

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED CE	APPROVED HA	DRAWING NO. D2360	REV. D SHEET 1 OF 2
DATE 07.06.06		TITLE LITTER TIE DOWN ASSEMBLY (LOCKING) NTS	
A	95.02.10	NEW ISSUE	
B	95.02.20	RE-DESIGN	
C	97.08.27	ADD MS20470AD3-4 RIVET	
D	07.06.06	D2002-015 WAS D2376; SECTION B-B QTY(2) AN960JD10 WAS QTY(3) QTY(8) AN960JD10L WAS QTY(5)	

PARTS LIST:

QTY	PART NUMBER	DESCRIPTION
X	D2360	LITTER TIE DOWN ASSEMBLY (LOCKING)
1	D2341	LITTER TIE DOWN (LOCKING)
1	D2345	LOCK CHANNEL
2	D2366	LOCK HANDLE
1	D2367	KNOB (DELRIN)
2	D2372	QUICK RELEASE FASTENERS
1	D2373	SPRING
2	D2002-015	KNOB (DELRIN)
1	D2444	PIP PIN
1	AN526C1032R18	SCREW
2	AN960JD10	WASHER
8	AN960JD10L	WASHER
1	MS20470AD3-4	RIVET
3	MS21042L3	NUT (OR MS21042-3)
1	MS27039-1-13	SCREW
2	MS27039-1-15	SCREW
1	NAS679A3W	NUT

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